

ABSTRACT

A molten resin is prevented from entering between a surface of a sheet-shaped insert such as a label including a printed film or the like and a surface of an outer mold unit and the insert is prevented from being downwardly pushed, when a synthetic article in which the insert is bonded to the outer peripheral surface of the thin cylindrical molded body is injection molded by the insertion molding.

The insert such as a label is fitted, closely attached and held along an inner peripheral surface of the outer molding unit in a cavity 7 defined between the outer mold unit 11 and the core 6, a molten resin is injected, through plural injection gate openings 9a provided in the core, toward an inner peripheral surface of the molded body at a position inwardly apart from an end of the insert in an axial direction and corresponding to an inner portion as viewed in width directions from opposite sides of the insert, the cavity is filled with the molten resin while the insert is being pushed to the surface of the outer mold unit with the molten resin, and the molten resin is integrated with the insert, thereby molding the label-attached cylindrical article 10.